

Work Order ID 148496

Monday, July 04, 2016 7:51:53 AM

148496

Page 1

Item ID: D5321-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Ring

Start Date: 7/8/2016 Start Qty: 60.00

60

Cust Item ID:

Required Date: 7/15/2016 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date: JUL 05 2016
QC: 9-32 Date: _____

Tooling:

Date: _____

SPC (Y/N):

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5321	B								

100

0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 32956
Possible supplier: ANCRA
Supplier P/N: 48557-11

C of C is required.

0.00

JUL 07 2016

DAS
73
989

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

0.00

60x SP16-7-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : ☐									

Work Order ID 148496

Monday, July 04, 2016 7:51:53 AM

148496

Page 2

Item ID: D5321-3

Accept

N900040100

Setup Start

NS1

Revision ID:

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NS2

Item Name: Ring

Start Date: 7/8/2016 Start Qty: 60.00

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60

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 38 9-89
120						60			
QC	Memo	0.00							
Quality Control									JUL 20 2016
130	Identify as per dwg & Stock Location: <u>SH64</u>	0.00							
130						60			
Packaging	Memo	0.00							DAS 8 9-89
Packaging									JUL 21 2016
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							DAS 21 9-89
Quality Control									JUL 22 2016

DAS
21
9-89 JUL 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

Picklist Print

Monday, July 04, 2016 7:51:57 AM

Page 1

Work Order ID: 148496

148496

Parent Item: D5321-3

D5321-3

Parent Item Name: Ring

Start Date: 7/8/2016

Required Date: 7/15/2016

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP REV:A 15.10.13 NEW ISSUE DD VERF:JLM IPP
REV:B 16.03.28 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

48557-11

Purchased

No

Each

0.0000

60

48557-11

Ring

**

60 x Sp/6-7-20

DQA: _____ Date: _____



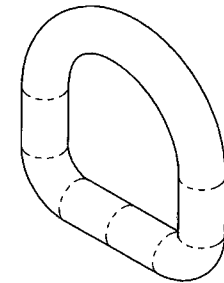
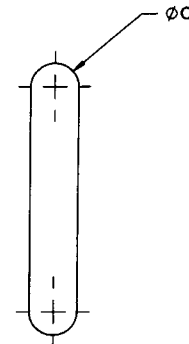
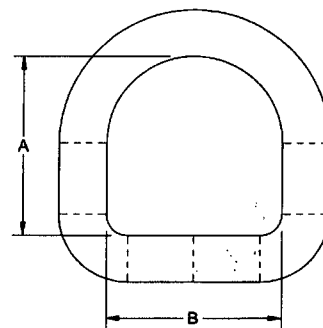
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

SPECIFICATION CONTROL DRAWING



D5321-X RING

PART NUMBER	VENDOR	VENDOR P/N	BREAK STRENGTH	WORKING LOAD LIMIT	WEIGHT	DIM 'A'	DIM 'B'	DIM 'C'	MATERIAL
D5321-1	U.S.C.C.	MR15	6,000 lbs	2,000 lbs	0.22 lbs	1.50	1.45	0.39	ZINC PLATED STEEL
D5321-3	ANCRA	48557-11	5,000 lbs	1,666 lbs	0.09 lbs	1.50	1.50	0.25	CAD PLATED STEEL
D5321-5	MCMaster-CARR	9372T21	600 lbs	200 lbs	0.05 lbs	0.81	1.06	0.22	NICKEL PLATED STEEL

△

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: SEE TABLE

STOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
148496 MJS
16-07-05

B	ADD D5321-5	DB	16.02.08
A	NEW RELEASE	DB	15.09.30
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	ML	DRAWING NO.	REV. B
MFG. APPR.	DD	D5321	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	RING	NTS
DATE	16.02.08	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-03-23
2016-548

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32956

Purchase Order Date 7/7/2016 3:25:58 PM
PO Print Date 7/7/2016

Page Number 1 of 2

Order From :

VU-ANC001

Ship To : DART AEROSPACE LTD

ANCRA INTERNATIONAL, LLC
25591 NETWORK PLACE
CHICAGO, IL 60673-1255
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

FedEx Economy collect

Ship Acct:

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

USD

FCA - (Free Carrier)

JUL 08 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	48557-11 ✓ AS PER DWG D5321 REV. B B148496	Ring ✓	7/28/2016 Yes 7/28/2016	FN	60.00 Each	\$6.95	\$417.00
Line Total:							\$417.00
2	71401-45 Procurement Quality Clauses	PROCUREMENT QUALITY CLAUSES	7/28/2016 No 7/28/2016		1.00	\$0.00	\$0.00
Line Total:							\$0.00

Note:

7/7/2016



ANCRA
INTERNATIONAL LLC

875 West 8th Street
Azusa, California 91702

Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 803858-1

Customer
Order

P032956

Order
Date

07-08-16

Page

1

Ship To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Bill To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

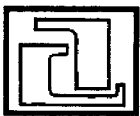
Ship Via: Special Instructions
Ship from: W ANCRA WEST AZUSA

Contact : SUE BEDFORD

Freight Terms : SSI

rd Ent By:	avillalobos	Sell	Sell Qty	To Stk	Bin	Stock Qty	Shipped
n Item		UM	Ship...	UM	Loc	To Ship	Qty/UM
o Number	Description						
1 48557-11	Facility W :D-RING- 1 1/2"	EA	60	EA	STOCK	60	60
	Cust PN: 71900-90						
	Rev. Level: G						
** Special Instructions **							

SHIP VIA FEDEX GRND.							
Allocated: 07-18-16							
Printed: 07-18-16 07:33:49							



ANCRA
INTERNATIONAL LLC

875 West 8th Street
Azusa, California 91702

Phone: (310) 973-5000 • FAX: (310) 973-1138

Shipping List Number 803858-1

Customer
Order

P032956

Order
Date

07-08-16

Page

2

Ship To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Bill To: 100312
DART AEROSPACE LTD
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Via: Special Instructions
Ship from: W ANCRA WEST AZUSA

Contact : SUE BEDFORD

Freight Terms : SSI

rd Ent By: avillalobos

Item No	Description	Sell UM	Sell QtyShip...	To Stk UM	Bin Loc	Stock Qty To Ship	Shipped Qty/UM
------------	-------------	------------	-------------------------	--------------	------------	----------------------	-------------------

CERTIFICATE OF CONFORMANCE

WE HEREBY CERTIFY THAT THE ABOVE STATED PART NUMBERS REPRESENTED ARE NEW AND HAVE BEEN MANUFACTURED AND INSPECTED IN ACCORDANCE WITH OUR QUALITY ASSURANCE MANUAL, ALL RELEVANT DRAWINGS, SPECIFICATIONS, PURCHASE ORDER REQUIREMENTS, AND LEGIBLY MARKED IN ACCORDANCE WITH FAR 45.15, IF APPLICABLE.

ALL CHEMICAL, PHYSICAL OR FUNCTIONAL TEST REPORTS RELEVANT TO THE CERTIFICATION OF CONFORMANCE ARE ON FILE IN OUR QUALITY ASSURANCE OFFICE.

INSPECTOR _____

DATE 7/18/16

Shortage Claim Policy

Ancra customer is responsible for inspecting incoming shipments. Ancra must be notified within fifteen(15) days of receipt of shipment if material is not as ordered, quantity is either surplus or short, or if any damage has occurred in shipment. No claims submitted to Ancra will be accepted after fifteen(15) days of receipt.

Pay
Terms

NET 30

1. The first step is to identify the problem. This involves understanding the current situation and the goals that need to be achieved.

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED
DATE 08-09-2007 BY 60322 UCBAW/SJS/TLS

1. The first group of people who were arrested in the early 1930s were the "Old Bolsheviks" who had been active in the Russian Revolution and the early years of the Soviet Union. They were seen as a threat to the new regime because of their long experience and influence.

DATE OF ISSUE: 16/04/2015

[illegible][illegible]

CONFIDENTIAL
ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED
DATE 05-08-2001 BY 60322 UCBAW

SECRET

0A-6C-1A

SECRET

SECRET

20120404 14:54 HP 7261.31281